

Date: Tuesday, 03/03/2009 1:01:43 PM
 User: Linda Lacelle

Process Sheet

Customer :	CC-DAR01 Dart Aerospace Ltd.	Drawing Name :	PAX SPEAKER MOUNT
Job Number :	46241		
Estimate Number :	10804		
P.O. Number :		Part Number :	D412785003401
This Issue :	03/03/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D412-785-003-401
First Issue :	/ /	Project Number :	
Previous Run :	46236	Drawing Revision :	
	Type :	Material :	
	SMALL /MED FAB	Due Date :	10/03/2009
Written By :		Qty:	28
Checked & Approved By :		Um:	Each
Comment :			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

IB 9-3-7

CUT PER DRWG D412-785-003-401 REV.A

MAT NOT PULLED

2.0	M2024T3S040	2024-T3 .040 sheet
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100740X11

(33)



Comment: Qty.: 0.0580 sf(s)/Unit Total: 1.6240 sf(s)

6061-T6 Sheet 0.032"

.040

109396X

22

IB 9-3-7

DEBUR

IB 9-3-7

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 9-3-7

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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9-03-11

Comment: SECOND CHECK

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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MB

Comment: HAND FINISHING RESOURCE #1

09-03-11

(33)

ACID ETCH AND ALODINE PER QSI005

6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

B/L

09-03-11

(33)

Date: Tuesday, 03/03/2009 1:01:43 PM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: PAX SPEAKER MOUNT

Job Number: 46241

Part Number: D412785003401

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
ID AND STK
PUT ASIDE TO SEND TO EAGLE

SS 09/03/12 (x33)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/12 Jy



Job Completion



12 09-03-12

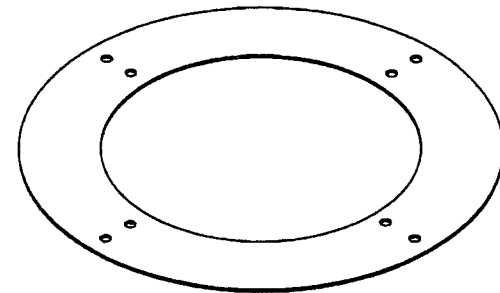
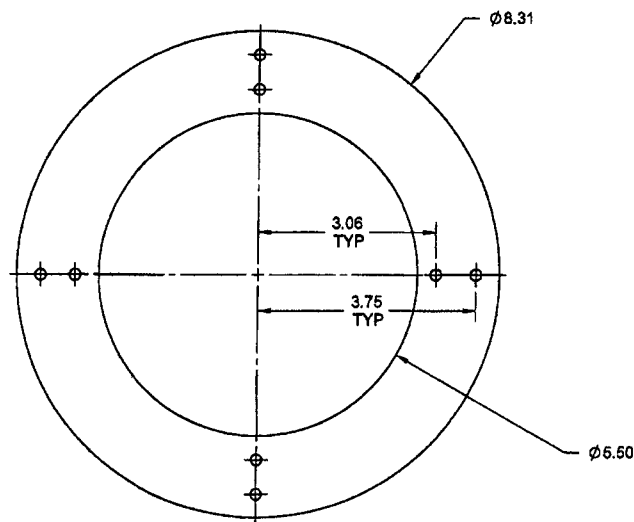
D 412 785 003.401

☒ First Article ☐ Prototype

Measured by: LB	Audited by: 	Prototype Approval: 
Date: 9-3-7	Date: 6-3-12	Date: N/A

H:\FORMS\Quality Assurance\approved QA\FAI revD

Handwritten signature



Handwritten: u/o 46241

0.040
REF

D412-785-003-401 PAX SPEAKER MOUNT AFT

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK PER AMS-QQ-A-250/4 OR AMS 4037
- 2) FINISH: ALODINE AND PAINT PER CUSTOMER REQUIREMENTS
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: N/A
- 7) WEIGHT: 0.12 lbs

A NEW ISSUE		BY <i>[Signature]</i>	08.12.04
REV	DESCRIPTION		DATE
DESIGN	RN.	EAGLE COPTERS MAINTENANCE	
DRAWN	<i>[Signature]</i>	CALGARY, ALBERTA, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	D412-785-003-401	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	N/A	PAX SPEAKER MOUNT	1:2
DATE	08.12.04	COPYRIGHT © 2008 BY EAGLE COPTERS MAINTENANCE THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. UNLESS SPECIFIED, THE EXPIRATION DATE OF THIS DOCUMENT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AIRSPACE LTD.	

L Lacelle

From: Kelly Labas [klabas@eaglecopters.com]
Sent: March 11, 2009 11:07 AM
To: 'L Lacelle'; 'Harvey Siemens'
Subject: RE: Hawker Parts

Morning Linda,

Go ahead and complete, both items are acceptable.

KL

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Wednesday, March 11, 2009 8:01 AM
To: 'Kelly Labas'; 'Harvey Siemens'
Subject: RE: Hawker Parts
Importance: High

Hi guys,

We cut the D412-785-001-403F, and the .098 holes are oversized by .005 (very thin mat'l for the size of the hole on the waterjet), are these acceptable?

Also for the D412-785-003-401, when you turn these pieces around, none of the holes match up, are these ok? Please advise asap, so we can alodine and ship today.

Thx

Linda

From: Kelly Labas [mailto:klabas@eaglecopters.com]
Sent: March 9, 2009 6:10 PM
To: 'L Lacelle'
Subject: RE: Hawker Parts

Hey Linda,

Do you have date for shipping these parts to us?

KL

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Monday, March 02, 2009 12:09 PM
To: 'Harvey Siemens'
Cc: 'Kelly Labas'; 'Crystal Benoit'
Subject: RE: Hawker Parts

Whoa....I thought these were just waterjet parts? These look more complicated than that!

From: Harvey Siemens [mailto:hsiemens@dartaero.com]
Sent: March 2, 2009 2:03 PM
To: 'L Lacelle'
Cc: Kelly Labas; 'Crystal Benoit'

11/03/2009

Subject: Hawker Parts

Linda

Please find attached the dwgs and DXF for the sheet metal parts that Eagle needs. I expect that Crystal (or someone else from purchasing) will be getting you a PO showing quantities etc.

I realize that these drawings have not been signed off by anybody over there. Hopefully they will still be OK.

Let me know if there is anything else that you need.

Regards,

Harvey Siemens

Mechanical Designer
DART Aerospace Ltd.

P: 403-717-0328

F: 403-717-1288

E: hsiemens@dartaero.com

W: www.dartaero.com

M: 1060 McTavish Road NE, Calgary, Alberta, T2E 5G9

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11/03/2009

L Lacelle

From: Kelly Labas [klabas@eaglecopters.com]
Sent: March 12, 2009 1:54 PM
To: 'L Lacelle'
Subject: RE: hawker parts

All good, Thanks

KL

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Thursday, March 12, 2009 11:43 AM
To: 'Kelly Labas'; 'Harvey Siemens'
Subject: RE: hawker parts

I'm shipping everything that I have, there will be 2 of these on b/o.
Also....2 parts were made with 6061T6, instead of 2024T3 – D412-785-003-401 and D412-785-004-403F...are these acceptable?
Also...some parts we made 1 or 2 extra, I am sending you these as well, just leave your P.o as is.
LL

From: Kelly Labas [mailto:klabas@eaglecopters.com]
Sent: March 12, 2009 1:32 PM
To: 'L Lacelle'; 'Harvey Siemens'
Subject: RE: hawker parts

Six is what I need, the seventh is back up. But it does have to be 6061-T6. How long to get more material? Can you send me as many as you have?

KL

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Thursday, March 12, 2009 10:51 AM
To: 'Kelly Labas'; 'Harvey Siemens'
Subject: RE: hawker parts
Importance: High

Do not have enough mat'l to make 7, can we use another mat'l, 2024?
LL

From: Kelly Labas [mailto:klabas@eaglecopters.com]
Sent: March 12, 2009 9:09 AM
To: 'L Lacelle'; 'Harvey Siemens'
Subject: RE: hawker parts

Hi Linda,

No, please leave undrilled. Those holes will be transfered by the installer.

12/03/2009

KL

From: L Lacelle [mailto:llacelle@dartaero.com]

Sent: Thursday, March 12, 2009 5:01 AM

To: 'Harvey Siemens'

Cc: 'Kelly Labas'

Subject: hawker parts

Importance: High

Hi again,

On D412-785-004-401F, there are 4 extra holes from your dxfs that are NOT on the drwg, are these good?

Please see attached

Thank You,

Linda Lacelle

Production Manager

Dart Aerospace Ltd

12/03/2009